

I CLAIM:

1. A one-part liquid concentrated color developer replenisher composition, which comprises a 4(N-ethyl-N-2-hydroxyethyl)-2-methylphenylenediamine-containing developer, and a sufficient amount of a hydroxylamine antioxidant to extend the shelf-life of said composition comprising at least N,N-bis(2-sulfoethyl)hydroxylamine or a salt thereof, said composition further characterized by satisfactory developer performance.

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2. The one-part liquid concentrate color developer replenisher composition of claim 1 wherein the hydroxylamine antioxidant is a disodium salt of N,N-bis(2-sulfoethyl)hydroxylamine.

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3. The one-part liquid concentrate color developer replenisher composition of claim 1 wherein the hydroxylamine antioxidant comprises at least a salt of the N,N-bis(2-sulfoethyl)hydroxylamine in combination with at least one other hydroxylamine antioxidant.

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4. The one-part liquid concentrate color developer replenisher composition of claim 3, wherein the one other hydroxylamine antioxidant is diethylhydroxylamine or a salt thereof.

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5. A one-part liquid concentrated color developer replenisher composition, which comprises a 4(N-ethyl-N-2-hydroxyethyl)-2-methylphenylenediamine-containing developer, a shelf-life extending amount of a hydroxylamine antioxidant comprising at least N,N-bis(2-sulfoethyl) hydroxylamine or a salt thereof; a buffer for maintaining the pH of the composition in a range from about 10 to about 12, and a photographically acceptable solvent system, said composition further characterized by satisfactory developer performance.

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6. The one-part liquid concentrated color developer replenisher composition of Claim 5 which is a monophase concentrate.

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7. The one-part liquid concentrated color developer replenisher composition of Claim 5 which is a multiphase concentrate.

8. The one-part liquid concentrated color developer replenisher composition of Claim 6 wherein the monophase concentrate 5 comprises a polyhydric alcohol.

9. The one-part liquid concentrated color developer replenisher composition of Claim 7 wherein the multiphase concentrate comprises an upper caprolactam-containing phase comprising the 10 developer and the N,N-bis(2-sulfoethyl) hydroxylamine antioxidant or salt thereof, and a lower aqueous phase comprises the buffer.

10. The one-part liquid concentrated color developer replenisher composition of Claim 9 wherein the caprolactam-containing multiphase concentrate comprises a third phase in the form of a solid precipitate comprising a salt.

11. The one-part liquid concentrated color developer replenisher composition of Claim 5 which is a diphase concentrate comprising a polyhydric alcohol-containing liquid phase and a solid phase comprising a salt.

20 12. A method for preparing a stabilized one-part liquid concentrated color developer replenisher composition, which comprises the steps of:

25 (i) dissolving a 4(N-ethyl-N-2-hydroxyethyl)-2-methyl-phenylenediamine-containing developer in an alkaline solution comprising a base, and an antioxidant comprising at least N,N-bis(2-sulfoethyl)hydroxylamine or a salt thereof;

(ii) introducing a photographically compatible organic solvent, and

30 (iii) introducing a buffering agent to maintain the pH of the solution in a range from about 10 to about 12, said

composition further characterized by satisfactory developer performance.

13. The method of Claim 12 wherein the photographically compatible organic solvent is a polyhydric alcohol, and the one-part liquid concentrated developer replenisher composition is a monophase concentrate, said method including the step of removing a salt precipitate.

14. The method of Claim 12 wherein the photographically compatible organic solvent is a polyhydric alcohol, and the developer concentrate is a diphase system comprising a liquid phase and a solid phase comprising a salt.

15. The method of Claim 12 wherein the photographically compatible organic solvent is a caprolactam which forms a diphase system comprising an upper caprolactam-containing solvent and a lower aqueous phase, said method including the step of removing a salt.

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